Work Order ID 53318

October 30, 2009 10:17:10 AM

Item ID: D3281-2 **Accept**

Revision ID: D

Item Name: Floor Protector, Fwd RH

Setup Start / Stop

Start Date: 30/10/2009 **Start Qty:** 10.00

Required Date: 16/11/2009 **Req'd Qty:** 10.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** BJ **Date:** 09-10-30 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3281	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Insp. Stamp
100 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Cut Blanks	0.00 0.00	BB 09/11/09 X10
110 Thermoform Thermoforming Machine	THERMOFORMING MACHINE **Memo** Thermoform as per Dwg. D3281 and Folio FTA 008 □Dwg. Rev. D □Folio Rev. BD	0.00 0.00	BB 09/11/09 X10
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	BB 09/11/09 X10

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Item ID: D3281-2 **Accept**

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Item Name: Floor Protector, Fwd RH

Setup **Start** **Stop**

Start Date: 30/10/2009 **Start Qty:** 10.00

Required Date: 16/11/2009 **Req'd Qty:** 10.00

Cust Item ID:

Customer:

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Trim to Finished Dimensions	0.00 0.00						DL 09/4/04 x10	
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00						DL 09/4/05 x10	
150 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 2) S 09/4/17				x10	∅		

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Setup **Start** / **Stop**

Start Date: 30/10/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 16/11/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run **Start** / **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Packaging	0.00				9/11/19	10	SP	
	Memo	0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						09/11/26	
	Memo	0.00							

09-11-20

Picklist Print

October 30, 2009 10:17:15 AM

Work Order ID: 53318

Parent Item: D3281-2RevD

Parent Item Name: Floor Protector, Fwd RH

Start Date: 30/10/2009 **Required Date:** 16/11/2009

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,550.250	43.3300			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	1550.25	
~~106751~~	6.26	
110877	1543.99	

BB 04/11/09

X10.

DART AEROSPACE LTD	Work Order:	53318
Description: Floor Protector, Fwd RH	Part Number:	D3281-2
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

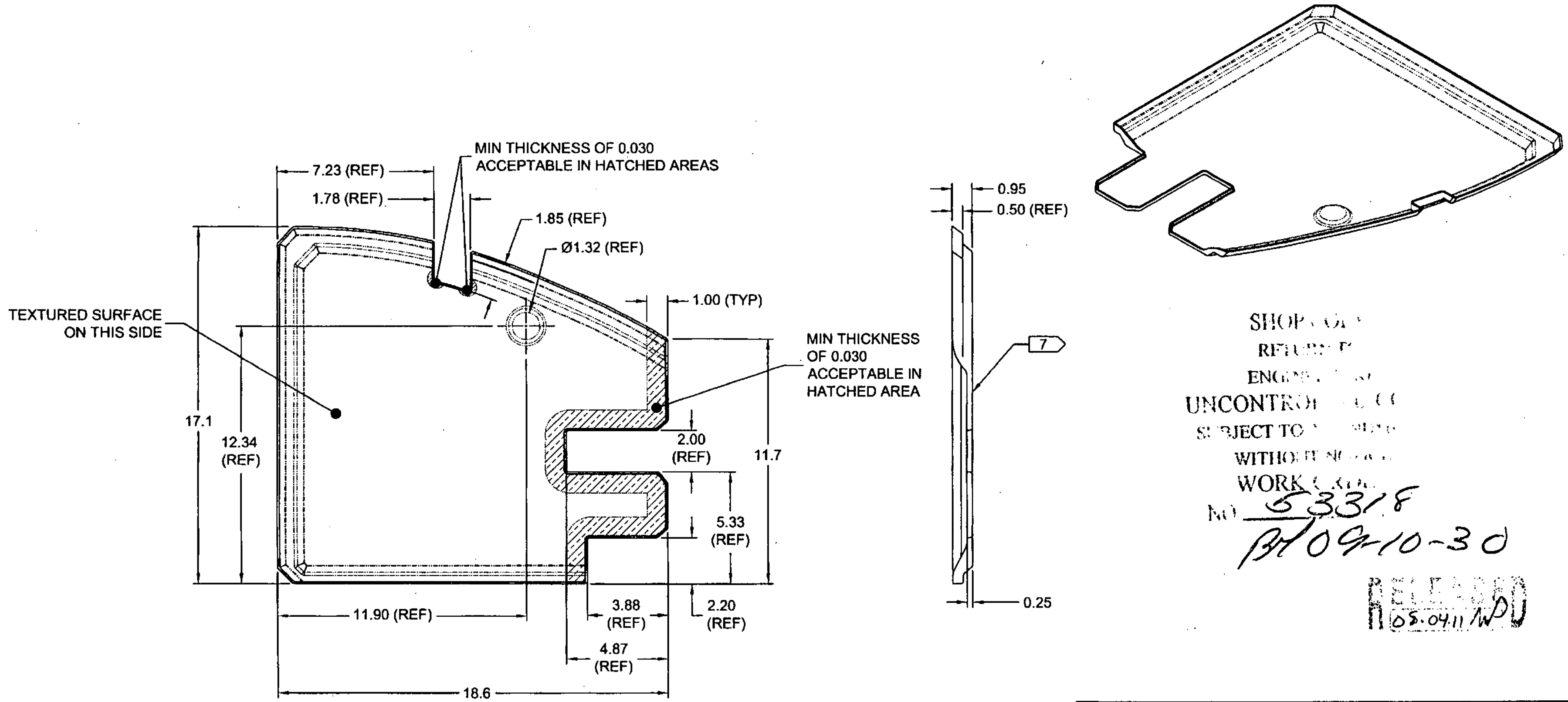
Measured by:	[signature]	Date:	09/11/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.25	✓			
17.4	+/-0.100	17.4	✓			
12.1	+/-0.100	12	✓			
0.95	+/-0.030	0.978	✓			
0.25	+/-0.030	0.256	✓			
0.030	Min	0.054	✓			
0.070	Min	0.72	✓			

Measured by:	[signature]	Date:	09/11/05
Audited by:	[signature]	Date:	07/4/17
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL [initials]	[initials]



D3281-1 FLOOR PROTECTOR

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BH 09-10-30

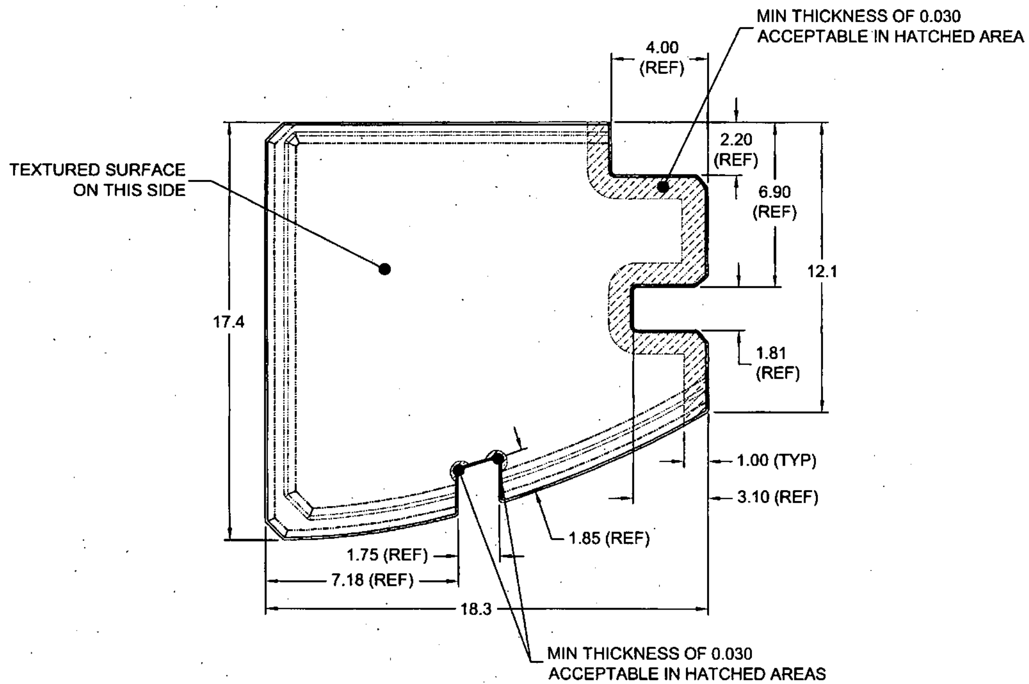
RELEASED 08.04.11 WD

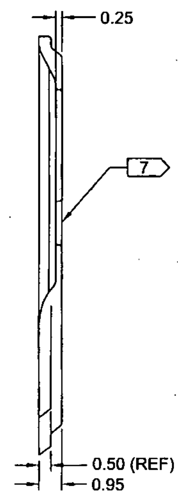
D3281-1 NOTES:

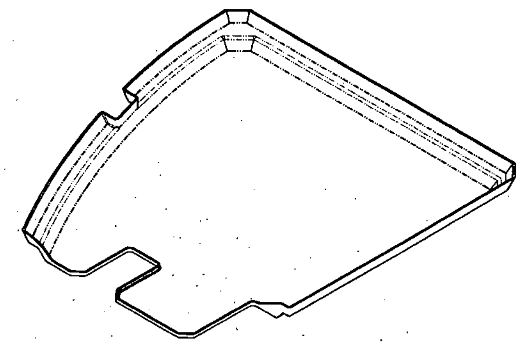
1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED (D)
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK (REF DART SPEC MLEXS.093-F6006-02) (D)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS (D)
8) WEIGHT: 0.95 lb (D)

REV.	DESCRIPTION	BY	DATE
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3281 — REV. D — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE: FLOOR PROTECTOR — SCALE: NTS
DE APPR.		
DATE	08.03.28	







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NO. 53318

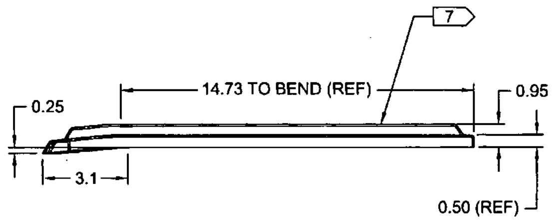
RELEASED 06.11.04

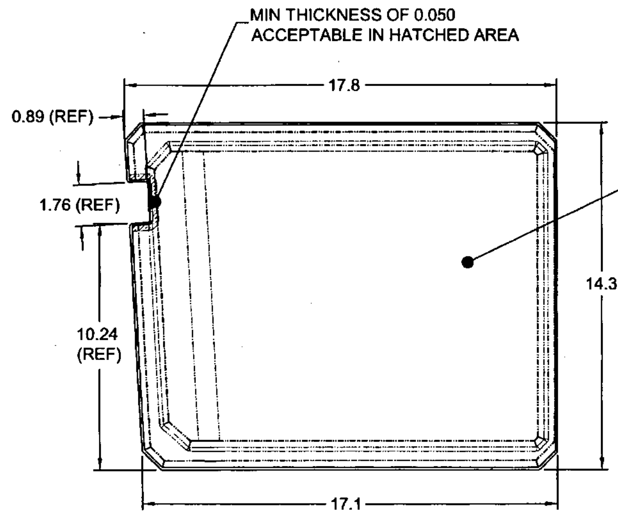
D3281-2 FLOOR PROTECTOR

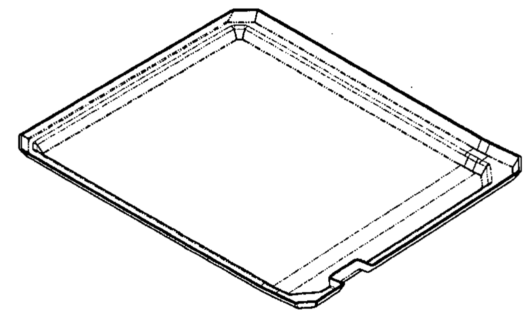
D3281-2 NOTES:

1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED (D)
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
   (REF DART SPEC MLEXS.093-F6006-02) (D)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS (D)
8) WEIGHT: 0.97 lb (D)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	08.03.28		







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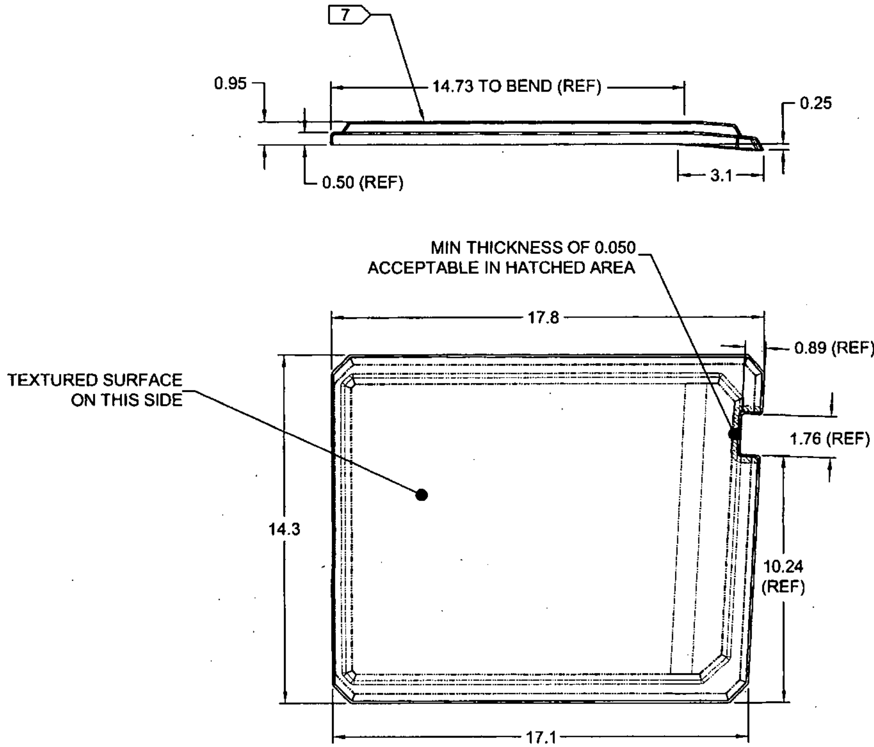
D3281-3 FLOOR PROTECTOR

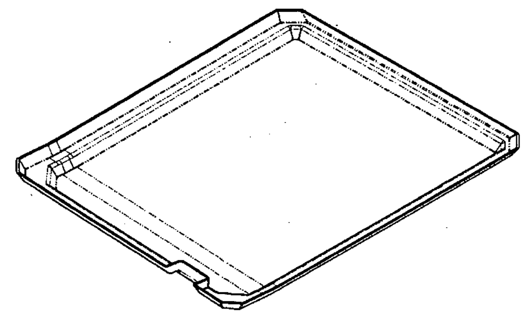
RELEASED 08.04.11

D3281-3 NOTES:

1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED (D)
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
   (REF DART SPEC MLEXS.093-F6006-02) (D)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX"ON SMOOTH SIDE OF PART USING VIBRATING STYLUS (D)
8) WEIGHT: 0.87 lb (D)

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D3281 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		FLOOR PROTECTOR NTS
DATE	08.03.28	





D3281-4 FLOOR PROTECTOR

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WITHOUT [illegible]
WORK ORDER
NO. 53318

D3281-4 NOTES:

1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED (D)
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
   (REF DART SPEC MLEXS.093-F6006-02) (D)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX"ON SMOOTH SIDE OF PART USING VIBRATING STYLUS (D)
8) WEIGHT: 0.87 lb (D)

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	08.03.28		